DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-027112
Date Inspected: 28-Jan-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Jobsite

CWI Name:	As noted below			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

12E/13E/A4 (Interior)

This QA Inspector randomly observed ABF welding personnel Wen Han Yu utilize the Plasma Arc Cutting (PAC) method to remove the backing bar from face “B” of “A4” at 12E/13E on the interior of the OBG. The welder employed the use of scaffolding to access the joint utilizing a “Bug-O” motorized rail system with a magnetic base attached in the (4G) overhead position to operate the PAC system. This QA Inspector noted the use of respiratory masks and proper safety procedures were followed. This QA Inspector made subsequent observations and noted that the work was in progress and appeared to be in general conformance with the contract documents.

13E/14E/D2/D3 MT (Interior)

This QA Inspector performed a Magnetic Particle (MT) Inspection at the locations listed below. This QA Inspector performed the yoke method in conformance with ASTM E 709 and the standard of acceptance with D1.5 section 6.26. This QA Inspector noted that no rejectable indications were found at the time of testing. This QA Inspector generated a TL-6028 MT report on this date. The completed work at this location appeared to be in general conformance with the contract specifications.

13E/14E/D3 -16mm thick
13E/14E/D2 - 22 mm thick

13E/14E/D2/D3 UT (Interior)

This QA Inspector performed Ultrasonic Testing (UT) on approximately 10% of the welds located at D2 and D3 of 13E/14E on the interior of the OBG. These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

12E/PP111/E3 Lifting Lug Hole W3 (Exterior)

This QA Inspector randomly observed QC Inspector Mr. John Pagliero perform an ultrasonic inspection of lifting lug hole W3 at 12E/PP111/E3 on the exterior of the OBG. This QA Inspector observed that Mr. Pagliero detected one (1) rejectable ultrasonic indication at y+325mm (depth/6mm, length/30mm). The “A” deck plate section is 20 mm thick.

13E/14E/A3/A4 (Interior)

This QA Inspector randomly observed ABF welding personnel grinding and blending the excessive reinforcement of completed weld on a partial section of A3 on the interior of the OBG. The welding personnel utilized a small disc grinder to finish the work to a near flush surface condition. This QA inspector also observed ABF welding personnel setting a Bug-O motorized rail welding system into place on A4 of 13E/14E on the interior of the OBG. This QA Inspector noted that no welding took place at this location.

Note: The QAI reviewed the observations and inspection with QA Lead Inspector, Daniel Reyes, written in this report. The issues were noted by the QAI and the QA Lead Inspector concurs with the QA report.

Summary of Conversations:

The were no pertinent conversations to report.

WELDING INSPECTION REPORT

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910 , who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer